

156297

Friday, January 27, 2017 12:53:04 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 1/18/2017 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 1/27/2017 Req'd Qty: 4.00

4

Customer:

Approvals:

Process Plan:

DAS
21
9-89

Date: FEB 01 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Draw Nbr	Revision Nbr
D3560	Rev D

100

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 16.750" long

110

0.06

HAAS 1

Memo

0.29

HAAS CNC vertical machine #1

1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: D

2 -Deburr per dwg D3560

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.01

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐																																																																

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156297

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 1/18/2017 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 1/27/2017 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong															
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions															
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Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :																					
Misidentified ☐	☐	Past Due	☐																						

Work Order ID 156297

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Item ID: D3560-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Arm

Start Date: 1/18/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/27/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00

210

Packaging

Memo

0.01

Packaging

LOCATION: WA003

4

DAS
6
9-89

FEB 4 2017

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.07

DAS
21
9-89

FEB 13 2017

Quality Control



FEB 10 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 156297

156297

Parent Item: D3560-1

D3560-1

Parent Item Name: Arm

Start Date: 1/18/2017

Required Date: 1/27/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.06.03 PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.00 0		Purchased	No				f	25.2650		5.873684			

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

**

SL 172-7

Location	Loc Qty	Loc Code
MAT	1.43	
nm134533	1.43	
MAT001	23.835	
m130527	0.045	
m134984	12	
m135377	11.79	

1.43
4.81

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
QC / QA Coordinator Approval 									

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

DART AEROSPACE LTD		Work Order: 156297
Description: Arm		Part Number: D3560-1
Inspection Dwg: D3560	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5065	/		g-DIN	
Ø0.196	+0.005/-0.001	.196	/			
Ø1.000	+0.010/-0.001	1.005	/			
0.500	+/-0.010	.505	/			
0.250	+/-0.010	.250	/			
0.275	+/-0.010	.275	/			
0.188	+/-0.010	.189	/			
2.000	+/-0.010	2.000	/			
1.700	+/-0.010	1.699	/			
Ø0.385 x 100°	+/-0.010 x 0.5°	0.380	✓		caliper	JCL-08
0.250 Deep	+/-0.010	.248	/			

Measured by: JCL	Audited by: B. 68-6	Prototype Approval:	N/A
Date: 17-02-08	Date: 17-02-08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.07.24	Dwg Rev updated	KJ/DD	

